

Thursday, 3/31/2005 10:05:37 AM
Kim Johnston

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER TIE DOWN ASS'Y (LOCKING)
Job Number : 26443 - 1	
Estimate number : 10495	
P.O. Number : N/A	Part Number : D2360
Date Issued : 3/30/2006 S.O. No. : N/A	Drawing Number : D2360 REV. C1
Print Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C1
Previous Part : N/A	Material : N/A
Written By : SEE COMIT	Due Date : 4/6/2006
Checked & Approved By : 93 06.03.30	Qty: 5 Um: Each
Comment :	

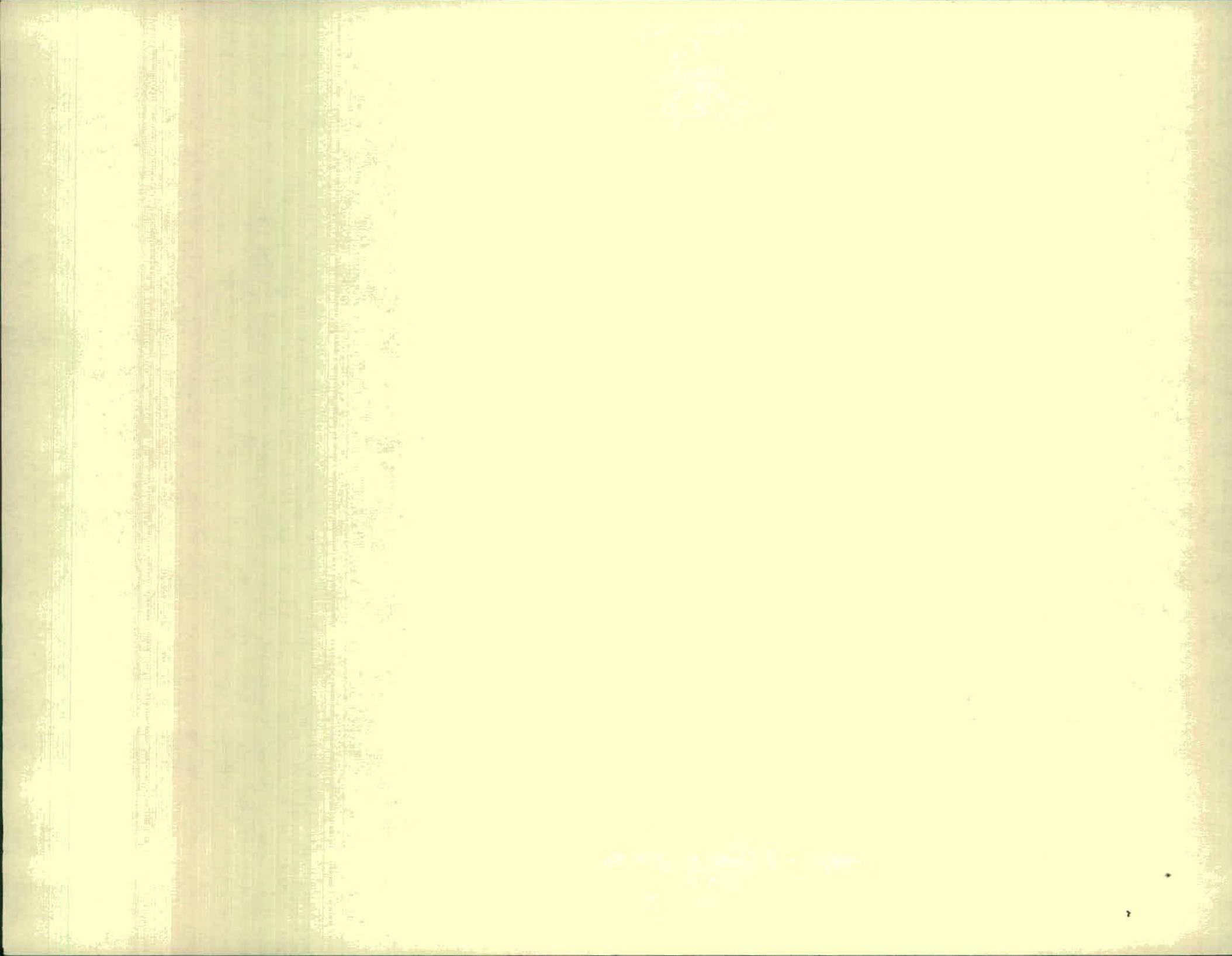
Additional product

• 19 Number



Seq. #:	Machine Or Operation:	Description :
1.0	D6201	T Extrusion 4X4X3/8
	Comment: Qty: 1.1067 f(s)/Unit Total: 5.5335 f(s)	
	Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)	
	Batch: B111722	TRL 06/04/02 5
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW	
	Cut blanks: 12.65" Long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	Machine as per Folio D2341 and Dwg D2341	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	Deburr and Tumble	J.G 06.04.03 5

Page 1



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26443

Part Number: D2360

Job Number:



Seq. # Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DC

06-04-04

5

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-04-04

B

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-04

B

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



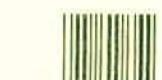
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DC 06/04/05

C

11.0 D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Knob

B 16 1770

12.0 D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Lock Channel

B13545 C

13.0 D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

B19488 C

14.0 D2367

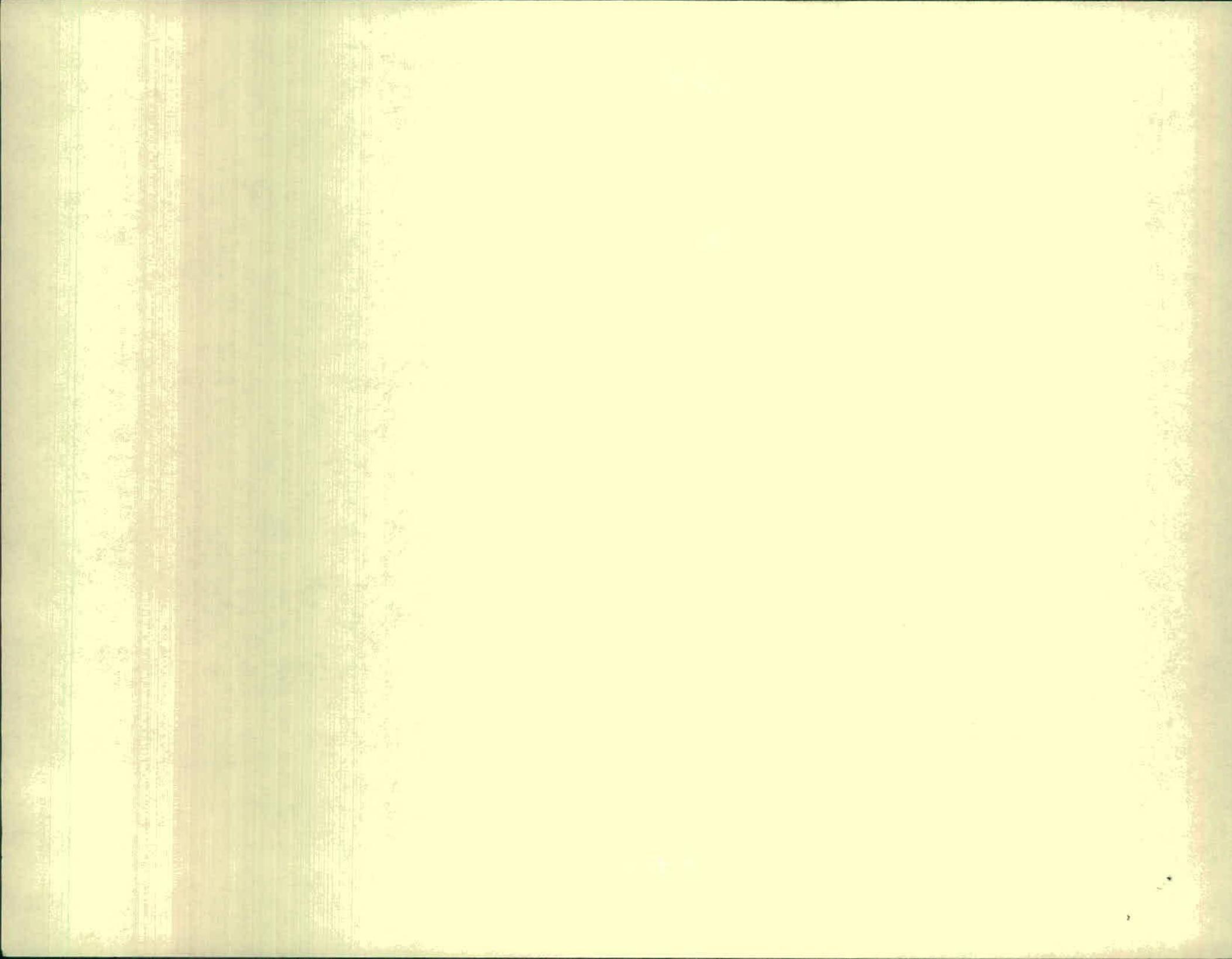
Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inventory

⑥ B18483
⑥ B26512 C



Process Sheet

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Job Number: 26443

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0 D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Quick Release

Q 19289 /

16.0 D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spring

B 19203 /

17.0 D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pip Pin Assembly

D 25324 /

18.0 AN960JD18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Screw

H 4023 /

19.0 AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

H 19521 /

20.0 AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

H 18235 /

21.0 MS20470AD34

Rivet,Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rivet,Universal Head

H 15541 /

22.0 MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

H 18917 /



Process Sheet

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Job Number: 26443

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation.

Description :

23.0 MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Screw

M13719 ✓

24.0 MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

M138432 ✓

25.0 NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

M19487

SR 06/04/06

26.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2360

SB 06/04/06



JUL 06.04.06

27.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



28.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST/71

C 06/04/06



29.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

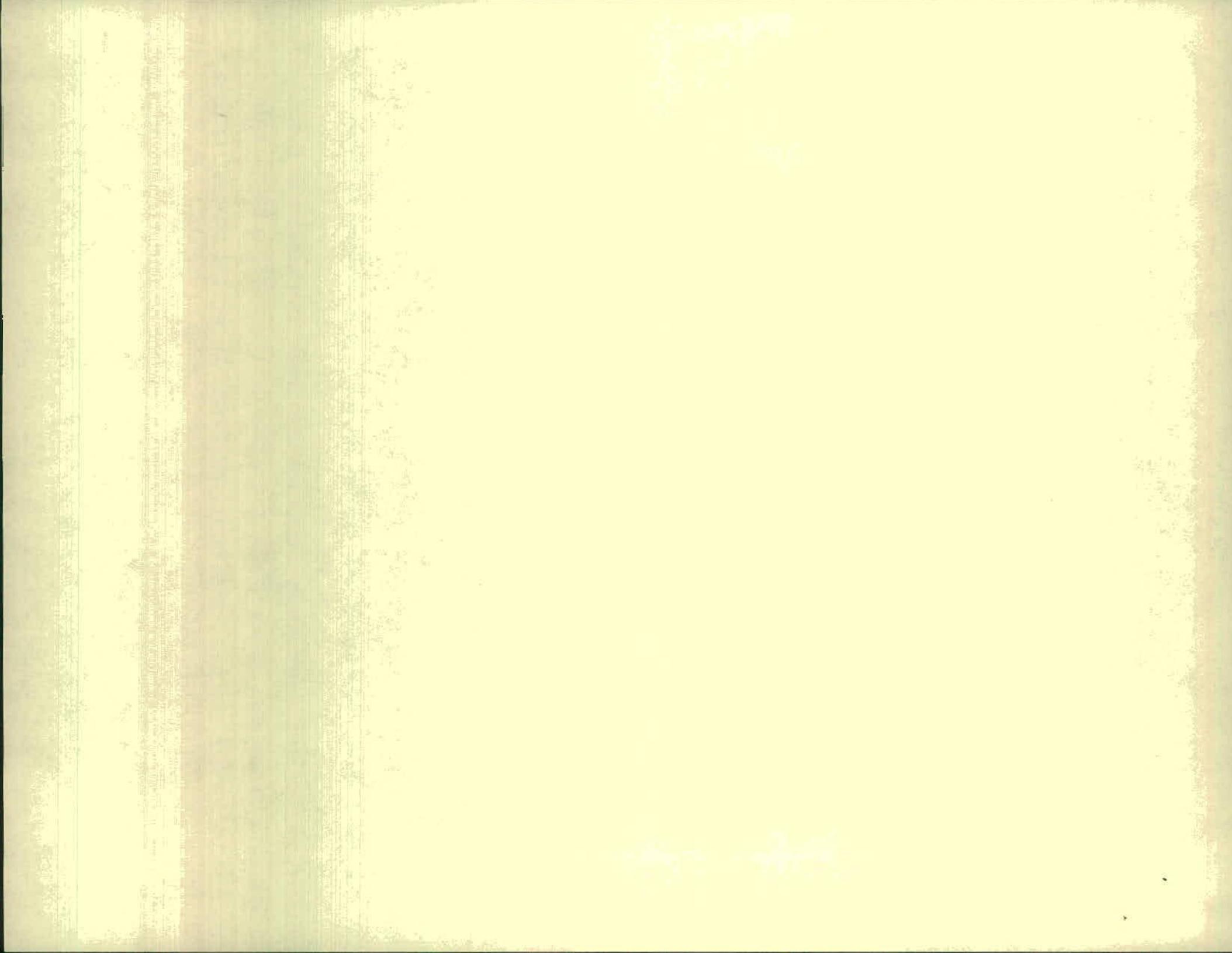


D 06/04/06

Job Completion:



U 06/04/06





OF COPY ISSUED
BY

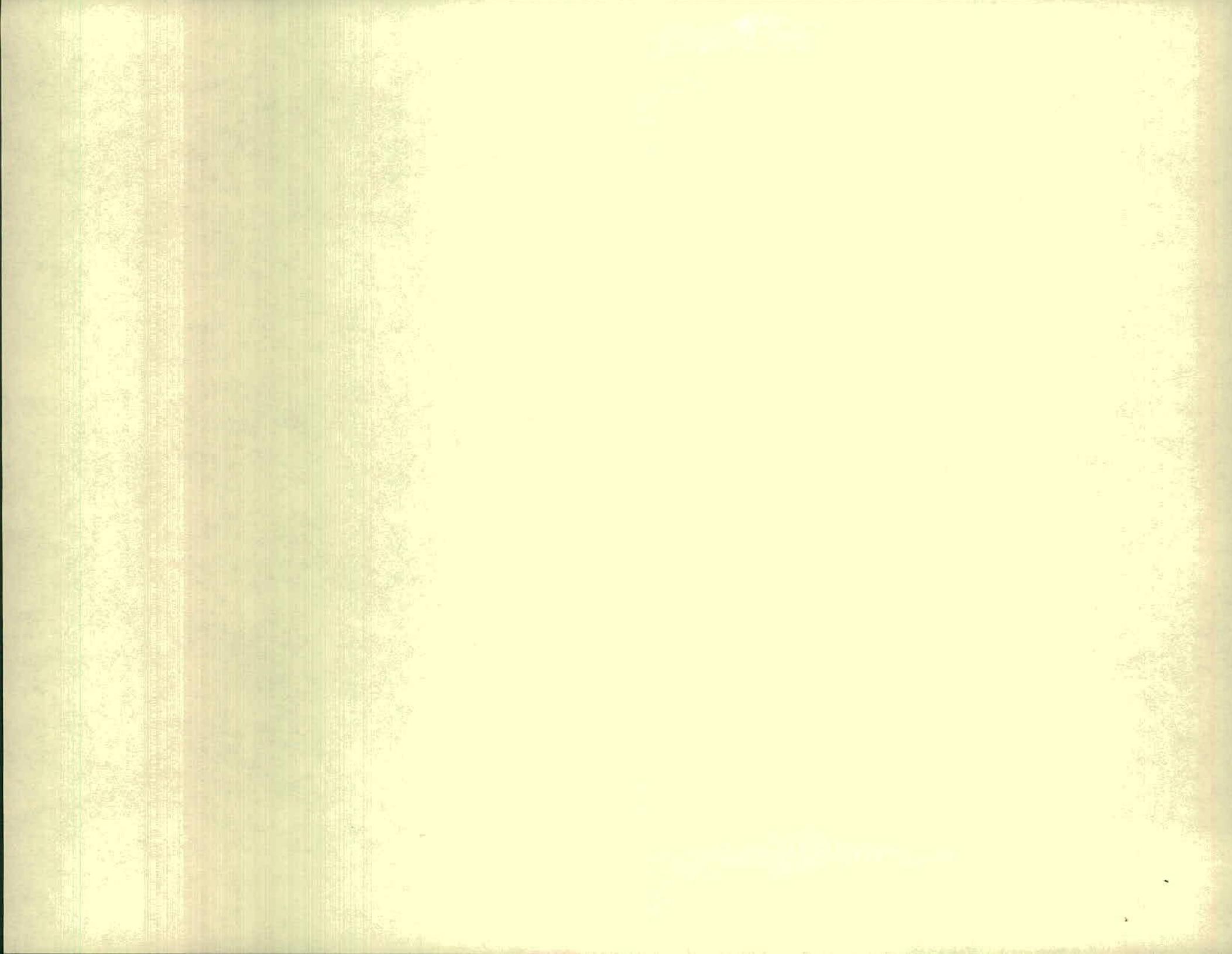
DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DMY</i>	DRAWING NO. D2360	REV. C SHEET 1 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)	SCALE

RELEASED
197.08.27 19.3

A	95.02.10	NEW ISSUE
B	95.02.20	RE-DESIGN
C	97.08.27	ADD MS20470AD3-4 RIVET
C1	02.09.24	D2002-015 WNS PL576

D2360	Part No.	Description
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LQCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2376	KNOB (DELRIN) D2002-015
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
3/2	AN960JD10	WASHER
5/3	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO DENIAL
WITHOUT NOTICE
WORK ORDER
NO. 26443



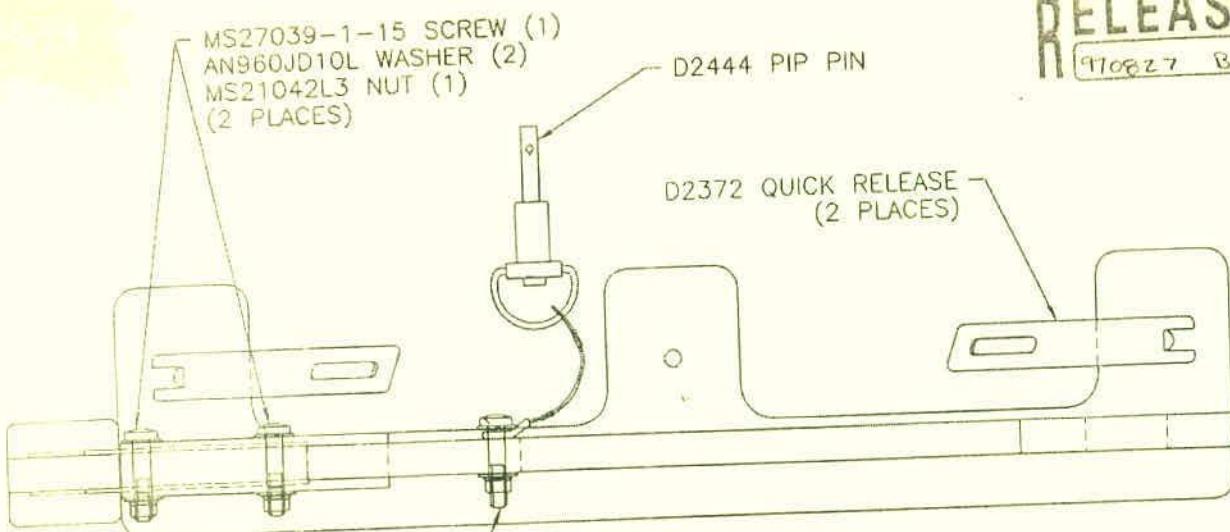


OF COPY
BY DRAFT

DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>LE</i>	APPROVED <i>MJ</i>	DRAWING NO. D2360
DATE 97.08.27		REV. C SHEET 2 OF 2 SCALE

LITTER TIE DOWN ASSEMBLY (LOCKING)

RELEASED
970827 BW



MS27039-1-13 SCREW
AN960JD10L WASH (3)
MS21042L3 NUT

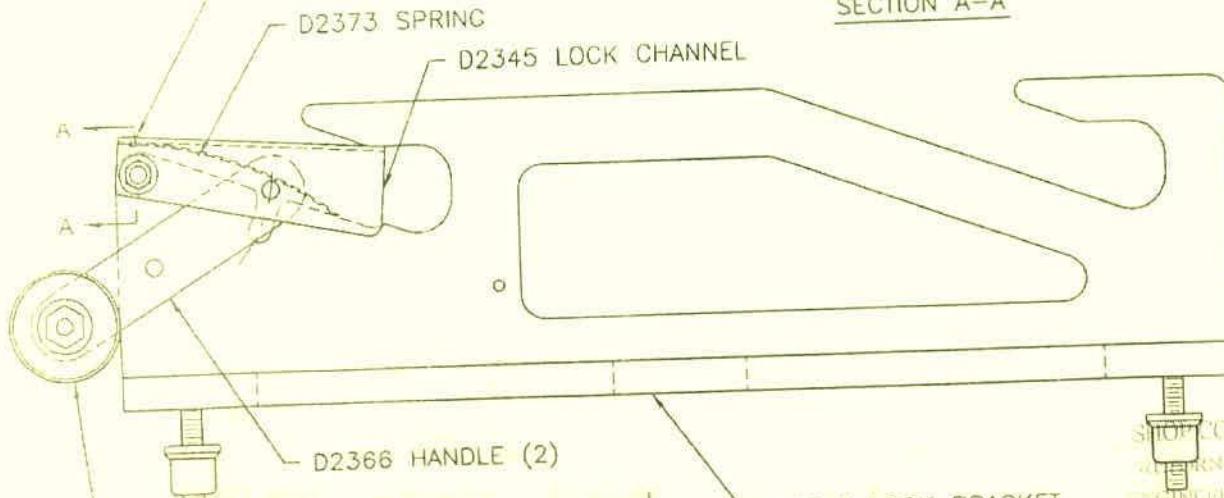
4E 9400764

MS20470AD3-4
(INSTALL FIRST HOLE FROM EDGE)

MS27039-1-15 SCREW (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(REF)

AN960JD10 WASHER (2)

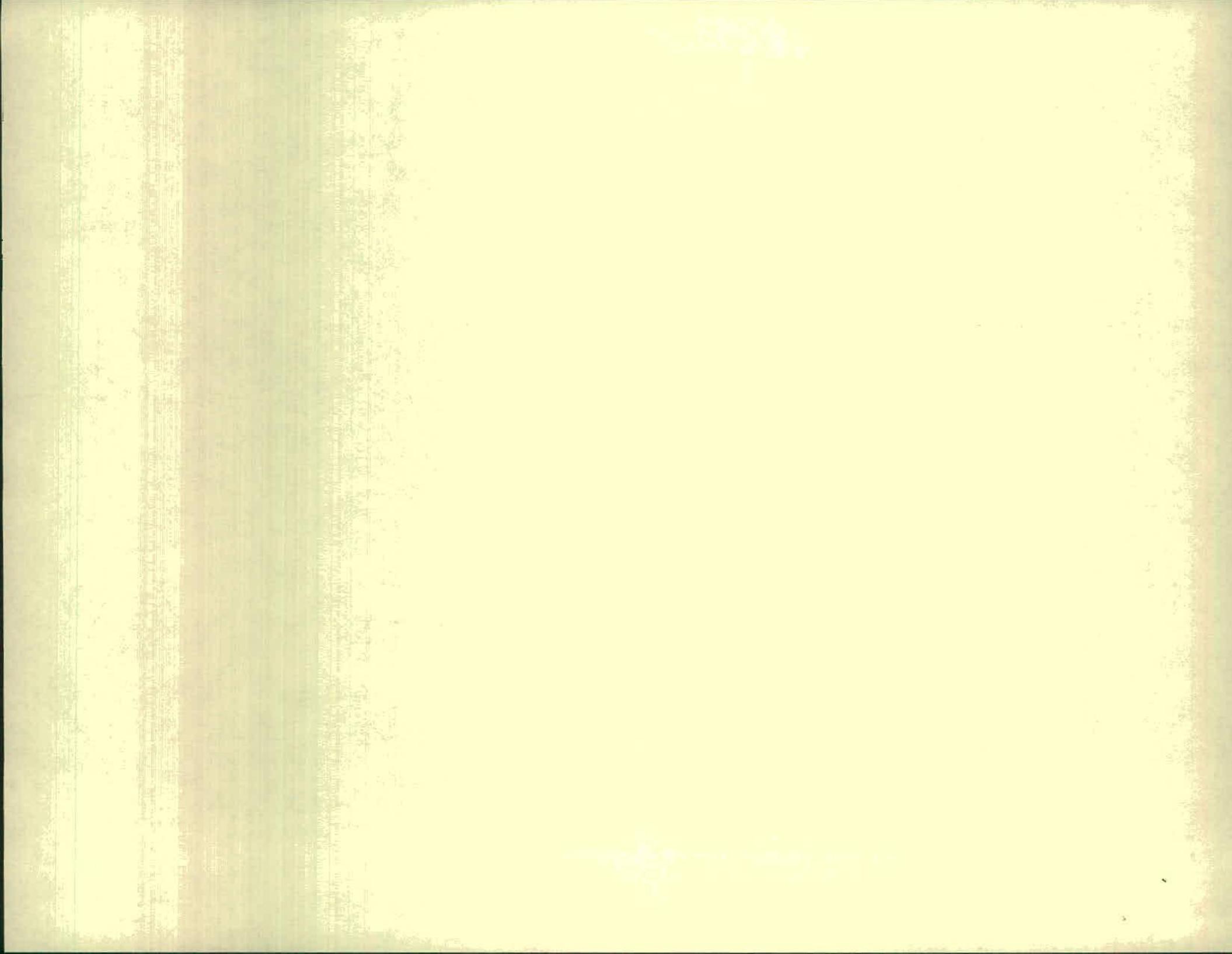
SECTION A-A



D2376 KNOB (2) D2002-015 KMB (2)
D2367 KNOB (1)
AN526C1032R18 SCREW (1)
AN960JD10L WASHER (1)
NAS679A3W NUT (1)

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDERED

NO 26443

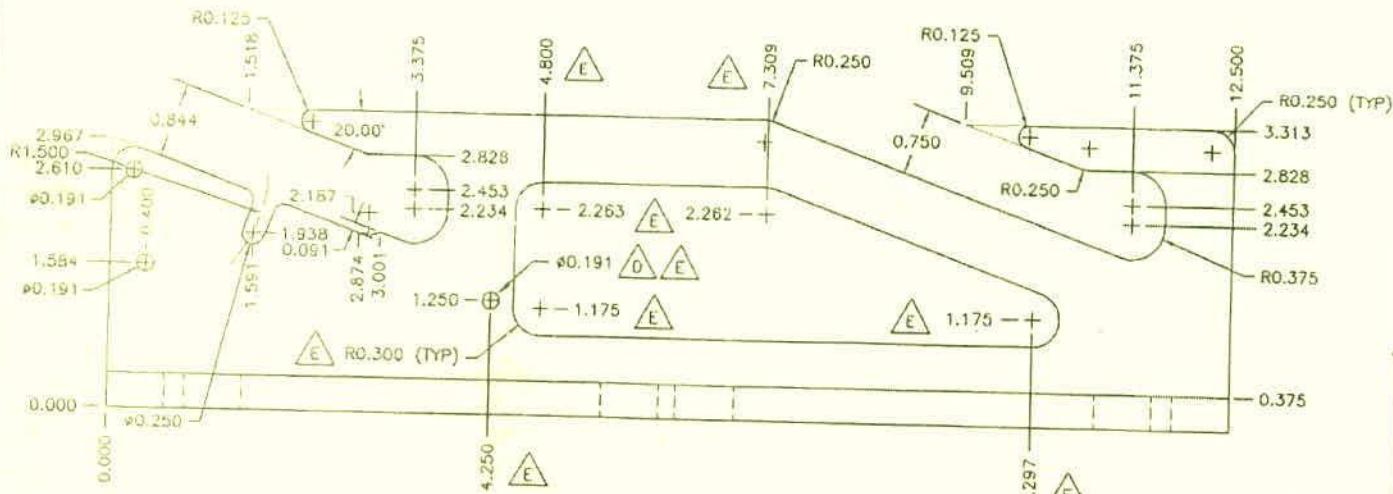
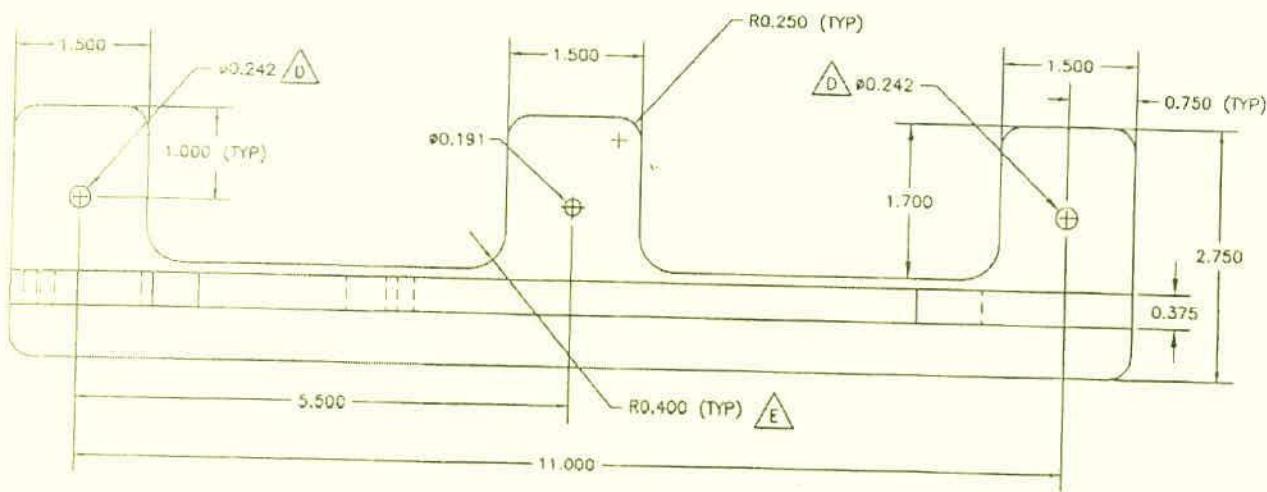


DART



DESIGN B.S.	DRAWN BY K.E.	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED M.W.	APPROVED B.S.	DRAWING NO. D2341
DATE 97.10.01		REV. E SHEET 1 OF 1
		TITLE LITTER TIE DOWN BRACKET (LOCKING) 1:2
A	95.01.13	NEW ISSUE
B	95.02.14	MODIFIED LOCK
D	95.02.20	CHANGES TO DIAMETERS
E	97.10.01	CHANGES FOR MACHINING

RELEASED
97.10.03 RE
T&R Airc



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 26443



WÖLFFEL

264/3

The Best Market

Fig. 4. (a) 1.5 mm (c)

22360

Key

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

1

Prototypen

Audited by

八

Prototype Approval

10

Revised by _____ Approved _____

